

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005933**Date Inspected:** 17-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie/Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components**Summary of Items Observed:**

On the date CALTRANS OSM Quality Assurance (QA) Inspector, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 6-OBG Assembly

This QA Inspector randomly observed the following work in progress:

Magnetic Particle Testing:

For Green Tag

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report on this date.

The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

1. DP 676-001 006, 024A 005316 10 BW
2. DP 702-001 001, 035A 005315 10 BE
3. BP 109-001 006,008,010,012 005311 11 EW
4. BP 052-001 007,009,011,013 005312 11 BW
5. BP 205-006 001 005314 6 C
6. BP204-006 002 005313 6C
7. SP 354-001 018,020,022,024 005310 11BE

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8. BP 081-001 007.008.010,012 005309 11DE

Bay# 6-Tower Assembly:

This QA Inspector randomly observed the following work in progress:

Magnetic Particle Testing:

For Green Tag

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report on this date.

The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

1. WSD1-DPSA3-11 8,9 004127 NA
2. SSD1-DPSA3-8 8,9 004126 NA
3. NSD1-DPSA3-7 8,9 004125 NA

FCAW Process:

Welding of weld joint# 9 located on PCMK NSD1-DPSA3-5. Welders are identified as 205766&058174. ZPMC QC is identified as Liu Zhi. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-2

Welding of weld joint# 11 located on PCMK NSD1-DPSA3-5. Welders are identified as 058174&205766. ZPMC QC is identified as Liu Zhi. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-2

SMAW Process:

Welding of weld joint# B/B-10 located on PCMK ESD1-DPSA3-17. Welder is identified as 066413. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5

Welding of weld joint# B/B-9 located on PCMK ESD1-DPSA3-17. Welder is identified as 066236. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5

Welding of weld joint# B/B-13 located on PCMK ESD1-DPSA3-17. Welder is identified as 066326. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5

Welding of weld joint# B/B-14 located on PCMK ESD1-DPSA3-17. Welder is identified as 037743. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5

Bay#- 5 OBG Assembly

This QA Inspector randomly observed the following work in progress:

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FCAW Process:

Welding of weld joint# 143&161 located on PCMK CB 201G-003. Welder is identified as 068919. ZPMC QC is identified as Zheng Zhi Wei. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2133

Welding of weld joint# 145&162 located on PCMK CB 201G-003. Welder is identified as 068919. ZPMC QC is identified as Zheng Zhi Wei. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2133

Welding of weld joint# 141&159 located on PCMK CB 201G-003. Welder is identified as 217562. ZPMC QC is identified as Zheng Zhi Wei. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3

Welding of weld joint# 141&159 located on PCMK CB 201G-001. Welder is identified as 217294. ZPMC QC is identified as Zheng Zhi Wei. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3

Unless otherwise noted, all work observed on this date appeared to be generally comply with applicable contract document

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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